

CLAIMS

New claims:

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13. A method for joining excitation poles to a pole housing of electromagnet machines formed as starter motors for starting internal combustion engines, comprising the steps of attaining a joining connection by positive and non positive engagement with spot shaping of a separate rivet which joins an excitation pole and the pole housing at least at one joining location, and employing the rivet in form of a blind rivet.

14. A method as defined in claim 13; and further comprising perforating the pole housing so that a rivet shank of the rivet is inserted through the perforated pole housing.

15. A method as defined in claim 13; and further comprising introducing the blind rivet into adjoining hole from outside of the pole housing.

16. A method as defined in claim 15; and further comprising perforating excitation poles so that a shank of the rivet is inserted through the

excitation poles; and widening of the rivet shank in association with a riveting operation downstream of a narrowing of a first hole segment in a second hole segment of a larger diameter than the first hole segment.

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cont

17. A method as defined in claim 16; and further comprising forming a hole in the excitation poles as a throughhole.

18. A method as defined in claim 16; and further comprising forming a joining hole in the excitation pole as a blind bore.

19. A method as defined in claim 18; and further comprising performing the narrowing of the joining hole in the excitation hole by drilling with a step drill.

20. A method as defined in claim 16; and further comprising performing the narrowing of the hole in the excitation pole by reverse upsetting of a bead created by perforation.

21. A method as defined in claim 13; and further comprising centering the excitation pole relative to the pole housing during riveting of the

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rivet shank which widens, by a conical form of a step attained in a perforation.

22. A method as defined in claim 13; and further comprising securing each excitation pole to an inside of the pole housing by two axially offset rivets.

23. An electrodynamic machine produced by a method including the steps of attaining a joining connection by positive and nonpositive engagement with spot shaping of a separate rivet which joins an excitation pole and the pole housing at least at one joining location, and employing the rivet in form of a blind rivet, the electrodynamic machine having the excitation poles secured to an inside of the pole housing; and the excitation poles are each joined to the pole housing by the rivet.